

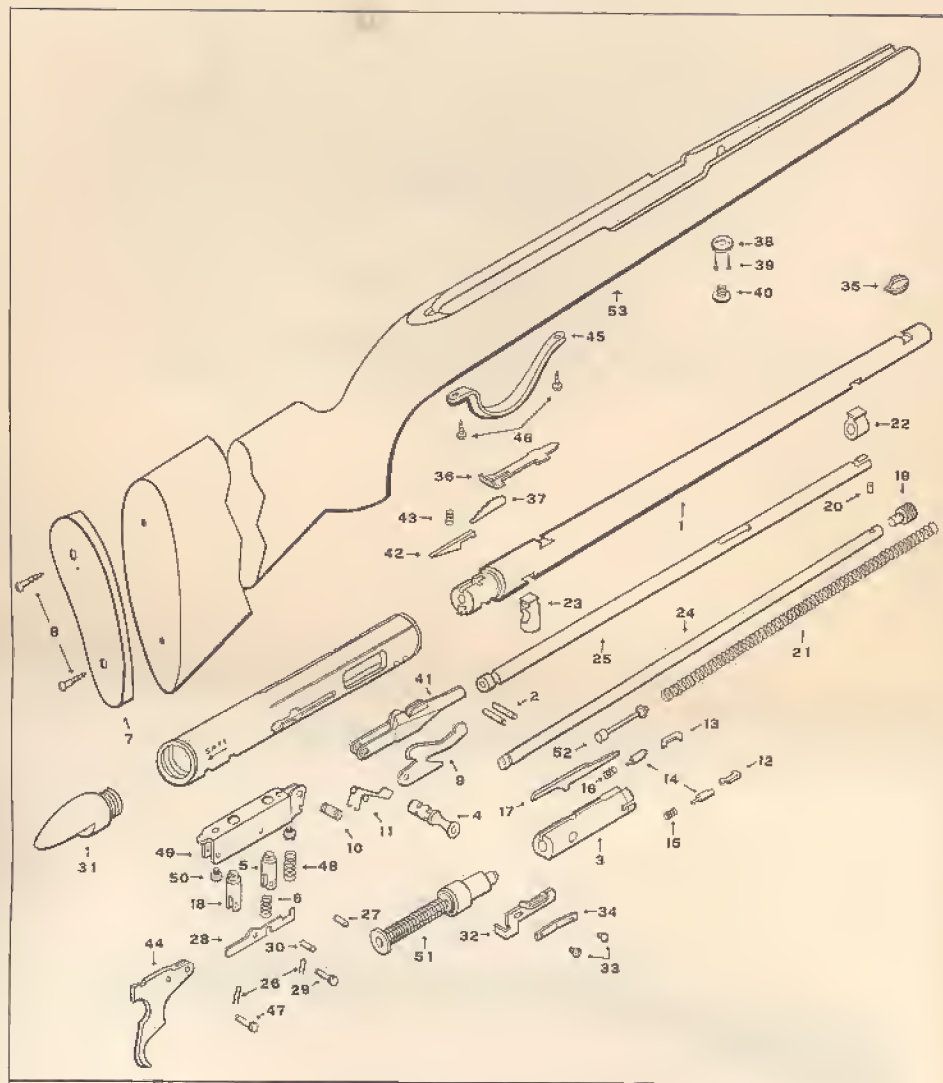
Sears

MODEL 25
.22 CALIBER AUTO-LOADING RIFLE

LIST of PARTS and ASSEMBLIES



**Sears Guns are sold ONLY by Sears, Roebuck and Co.
and Simpsons-Sears Limited**



SPECIFICATIONS

| | |
|-------------------|---|
| Length of Pull | 13 3/4 |
| Drop at Heel | 2 9/16 |
| Drop at Comb | 1 9/16 |
| Barrel Length | 22 1/4 |
| Overall Length | 42 3/4 |
| Weight of Gun | 5 lbs. - 10 oz. |
| Magazine Capacity | 15 Long Rifle, 17 Longs, or 21 Shorts (Hi-Speed only) |

Front Sight — Post Type

Rear Sight — Rocky Mountain partridge type
with serrated blade for eleva-
tion at 25 yard intervals.

Stock — Walnut Finish

PARTS LIST FOR
SEARS AUTO LOADING RIFLE
MODEL NO. 583.2501

WHEN ORDERING REPAIR PARTS, ALWAYS GIVE THE FOLLOWING INFORMATION AS SHOWN IN THIS LIST:

- | | |
|---------------------|----------------------|
| 1. THE PART NUMBER. | 3. THE MODEL NUMBER. |
| 2. THE PART NAME. | 4. THE NAME OF ITEM. |

All parts identified with a dagger (†) must be fitted to the gun by gunsmiths in Sears gunshops, or by qualified gunsmiths. Do not order repair parts by key number, always use the part number.

| KEY NO. | PART NO. | DESCRIPTION | KEY NO. | PART NO. | DESCRIPTION |
|---------|----------|---------------------------|---------|----------|------------------------------|
| 1 | 25000 | †Barrel | 30 | 25430 | Plunger Connector Stop Pin |
| 2 | 25010 | †Barrel Pins (2) | 31 | 25240 | Receiver Plug, Rear |
| 3 | 25030 | †Bolt | 32 | 25420 | †Safety |
| 4 | 25022 | Bolt Handle | 33 | 11430 | †Safety Screw (2) |
| 5 | 25060 | Bolt Plunger | 34 | 11435 | †Safety Spring |
| 6 | 25071 | Bolt Plunger Spring | 35 | 25621 | Sight, Front |
| 7 | 344 | Butt Plate | 36 | 478 | Sight, Rear |
| 8 | 345 | Butt Plate Screws (2) | 37 | 479 | Sight Elevator, Rear |
| 9 | 25170 | Cartridge Lifter | 38 | 11500 | Takedown Escutcheon |
| 10 | 25181 | Cartridge Lifter Pin | 39 | 11505 | Takedown Escutcheon Pins (2) |
| 11 | 25211 | Cartridge Lifter Spring | 40 | 11510 | Takedown Screw |
| 12 | 25271 | Extractor, R. H. | 41 | 25220 | Throat |
| 13 | 25281 | Extractor, L. H. | 42 | 25485 | Top Ramp |
| 14 | 25295 | Extractor Plunger (2) | 43 | 25490 | Top Ramp Spring |
| 15 | 25290 | Extractor Spring, R. H. | 44 | 25521 | Trigger |
| 16 | 25293 | Extractor Spring, L. H. | 45 | 11530 | Trigger Guard |
| 17 | 25300 | †Firing Pin | 46 | 11535 | Trigger Guard Screws (2) |
| 18 | 25231 | Hammer Plunger | 47 | 25510 | Trigger Pin |
| 19 | 25331 | Magazine Cap | 48 | 25515 | Trigger Return Spring |
| 20 | 328 | Magazine Cap Pin | 49 | 25405 | †Underbody |
| 21 | 4040 | Magazine Spring | 50 | 25410 | †Underbody Screws (2) |
| 22 | 25350 | Magazine Support, Front | | 25830 | †Bolt Assembly |
| 23 | 25355 | Magazine Support, Rear | 51 | 25840 | Hammer Assembly |
| 24 | 25380 | Magazine Tube, Inner | 52 | 25860 | Magazine Follower Assy. |
| 25 | 25385 | Magazine Tube, Outer | 53 | 25871 | Stock Assembly |
| 26 | 11580 | Pin Retaining Springs (3) | N.I. | 25867 | Magazine Tube Assembly |
| 27 | 25430 | Plunger Assembly Pin | N.I. | 25510 | Trigger Stop Pin |
| 28 | 25440 | Plunger Connector | N.I. | 10675 | Hammer Plunger Spr. |
| 29 | 25510 | Plunger Connector Pin | | | |

N.I. Not Illustrated.

MODEL 25

Look at the features built into this low priced semi-automatic rifle. It's easy to carry and fast handling for field shooting and plinking, with plenty of accuracy for target shooting too. As fast as you can pull the trigger, it will fire 15 L. R., 17 Long, or 21 Hi-Speed Shorts without any adjustment. The unique loading-port position permits rapid loading of magazine. The many custom features of this autoloading rifle have made it America's favorite among all .22 caliber rifles.

DISASSEMBLE

To remove action from stock turn gun upside down and loosen takedown screw until action is free from stock.

To remove bolt and hammer assembly, unscrew rear receiver plug from receiver. Pull bolt handle fully rearward and remove bolt handle. Remove hammer assembly from receiver, and with gun held in vertical position pull trigger rearward thus allowing bolt assembly to fall free from receiver.

IMPORTANT:

Before firing this rifle, be sure to clean barrel thoroughly of grease, or any obstruction.

CLEANING & LUBRICATING

The performance of any semi-automatic rifle depends on how clean it is kept. Exclusive use of Sears' ammunition will keep fouling to a minimum, but, because a semi-automatic rifle depends on the powder gases for the repeating action, it must be kept clean to function efficiently. We recommend that your gun be thoroughly cleaned after firing approximately 200 to 250 rounds for continued top performance.

Using a large round brass wire brush soaked in solvent, clean inside of receiver, removing all residue. Clean bolt and hammer assemblies getting powder residue out of extractors, off face of bolt and firing pin, and out of machined cuts in bolt. Soak magazine throats in solvent and push a brass brush with solvent through feed ramp several times removing powder residue.

Pull a patch, moistened with a good solvent through the barrel from the breech end. Pull a brass brush, soaked in solvent through the entire length of the bore several times, using long even strokes. Pull clean patches through the bore in the same manner until the last patch comes out unsoiled. Push lightly oiled patch through the entire length of the bore.

Wipe all component parts dry, oil lightly and replace, following assembly instructions.

ASSEMBLE

Bolt and Hammer Assembly

With gun on its side replace bolt by pulling trigger rearward and pushing bolt forward in receiver until bolt handle hole on side of bolt is in line with hole in receiver. Replace bolt handle and move bolt assembly fully forward. With trigger pulled rearward replace hammer assembly in receiver. Insert rear receiver plug and screw down until plug hits bottom, then back-off on plug until flat on plug is in line with flat portion of stock. Insert action in stock and tighten takedown screw until action is bedded in stock.

OPERATING INSTRUCTIONS

TO MAKE GUN SAFE: Thumb safety is located at top, rear of stock next to receiver, on right of gun. With hammer cocked, draw safety rearward under thumb of right hand. This movement locks trigger, and rifle cannot be fired. Always LOCK gun when carrying it, loaded.

TO RELEASE SAFETY: Push safety fully forward and gun is ready to be fired.

TO LOAD MAGAZINE: With safety on, turn knurled knob on inner magazine tube, pull tube out and insert cartridges into cartridge opening, continuing the operation until last cartridge is visible. Grasping knurled portion of inside magazine tube, press down with rotating action until magazine tube is fully down and located in supporting notch.

TO LOAD CHAMBER: Retract action fully to the rear and allow to close. Push safety fully forward. Gun is now ready to fire.

TO REMOVE CARTRIDGES; WITHOUT FIRING: Put safety on (rearward). Remove inside magazine tube, and by pointing gun muzzle downward, all cartridges in the magazine tube will drop into the hand. Replace inside magazine tube and work action two or three times removing cartridges from barrel chamber and magazine throat assembly. Pull bolt operating handle back and examine barrel chamber and magazine throat to make sure gun is now empty of cartridges.